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Hawkesbury, ON  
K6A 1K7  
Canada

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**D2673-34**  
**Job Sheet 190917**



**Part No:** D2673-34

**Job Qty:** 30 pcs

**Part Name:** End Plate



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/20/19

**Job Tracking No:**

**Due Date:** 4/15/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG REV B IPP C 02.01.14 Removed deburr and inspect level 5 NG/EC IPP Rev:D Now 6061-T6 06-06-23  
JLM IPP Rev:C Now on Waterjet 07-05-28 JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1         | 30 pcs | 4/15/19    | 4/15/19  | 0.01      | 0.49    | Waterjet - Flow       |           | PC 19/03/11 |
| 120   | QC 8                        | 30 pcs | 4/15/19    | 4/15/19  | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 47             |           |             |
| 130   | Packaging 3-1 - Stock - B4B | 30 pcs | 4/15/19    | 4/15/19  | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 5 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 6 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 7 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 8 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 9 - B4B |           |             |

DAS  
40  
9-89

MAR 12 2019

|                                                                                                                                                                                                                          |                       |                         |                         |                  |                         |             |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|-------------------------|-------------------------|------------------|-------------------------|-------------|
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 10 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 11 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 12 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 13 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 14 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 15 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 16 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 17 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 18 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 19 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 20 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 21 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 22 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 23 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 24 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 25 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 26 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 27 - B4B  | WA003       |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 28 - B4B  | MAR 13 2019 |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 29 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 30 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 31 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 32 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 33 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 34 - B4B  |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | Packaging 3 - 35 - B4B  |             |
| 140                                                                                                                                                                                                                      | QC 21 - SA            | 30 pcs                  | 4/15/19                 | 0.00 0.00        | QC 21 - SA - 21         |             |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | QC 21 - SA - 70         | MAR 13 2019 |
|                                                                                                                                                                                                                          |                       |                         |                         |                  | QC 21 - SA - 53         |             |
| Part Op 100 - 1-Cut as per Dwg D2673<br>Descriptions: 120 - QC8- Inspect parts - second check<br>130 - Identify as per dwg & Stock Location: _____ - LOCATION WA003<br>140 - QC21- Final Inspection - Work Order Release |                       |                         |                         |                  |                         |             |
| <b>Job BOM</b>                                                                                                                                                                                                           |                       |                         |                         |                  |                         |             |
| <b>Part / Item</b>                                                                                                                                                                                                       | <b>Component Name</b> | <b>Quantity</b>         | <b>Operation</b>        | <b>Container</b> |                         |             |
| M6061T6S.080                                                                                                                                                                                                             | 6061-T6 .080 Sheet    | 1.5600 sf (.052 ea)     | 100-Waterjet - Flow - 1 |                  | S152153                 |             |
| <b>Job Allocations</b>                                                                                                                                                                                                   |                       |                         |                         |                  |                         |             |
| <b>Operation</b>                                                                                                                                                                                                         | <b>Component Part</b> | <b>Required</b>         | <b>Inventory</b>        | <b>Allocated</b> |                         |             |
| 100-Waterjet - Flow - 1                                                                                                                                                                                                  | M6061T6S.080          | 2                       | 227                     | 0                |                         |             |
| <b>Part Specifications</b>                                                                                                                                                                                               |                       |                         |                         |                  |                         |             |
| <b>Spec No</b>                                                                                                                                                                                                           | <b>Description</b>    | <b>Target/Tolerance</b> | <b>Limits</b>           | <b>Type</b>      | <b>Special Comments</b> |             |
| 1                                                                                                                                                                                                                        | End Plate             | 3.300Inches ± 0.010     | 3.310<br>3.290          |                  |                         |             |
| 2                                                                                                                                                                                                                        | End Plate             | 2.247Inches ± 0.010     | 2.257<br>2.237          |                  |                         |             |
| 3                                                                                                                                                                                                                        | End Plate             | 0.250Inches ± 0.010     | 0.260<br>0.240          | Radius           |                         |             |

Plex 2/20/19 7:54 AM Dart.lajeunesse,marie

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



Container No: S161432



Part: D2673-34

Job No: 190917

Serial No/Batch: S161432

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/12/19